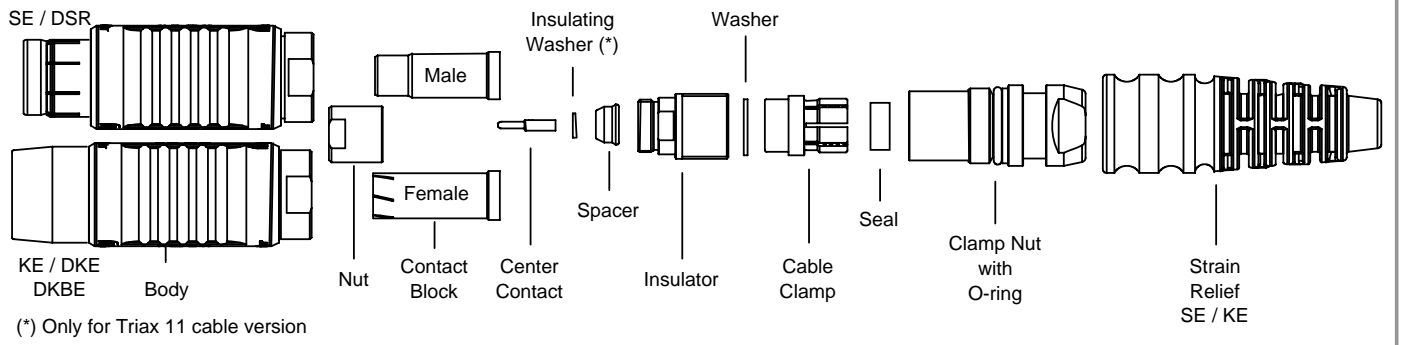


I - Tool Required

For all versions:	Fischer Part Number	Additional tools to crimp contacts:	Fischer Part Number
<ul style="list-style-type: none"> • Wire Cutter • Stripping Tool • Soldering Iron • Flat Spanners: <ul style="list-style-type: none"> • 12 mm (fork thickness: 3.0 mm) • 15 mm • 19 mm • 20 mm • 21 mm 	TX00.012 (2x) (*) TX00.015 -	<ul style="list-style-type: none"> • Crimping Tool • Positioner 	TX00.242 TX00.315

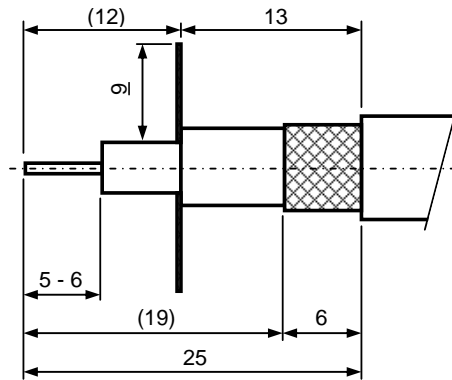
(*) The use of a "Breaking" Torque Handle is recommended.

II - Connector Parts



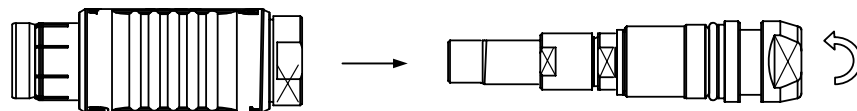
III - Cable Stripping Dimensions

All dimensions in mm.
 These values are given for reference.
 It is advised to strip the cable **step by step** as explained further in this document.



STEP 1 - Disassemble Connector

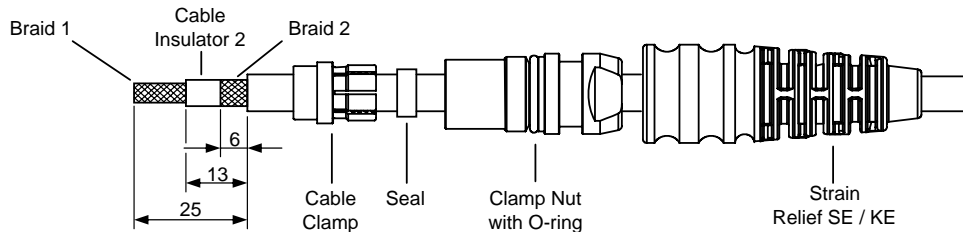
- 1.1 Loosen the Inner Assembly manually and remove it from the body.
- 1.2 Loosen screws manually and take out the parts.



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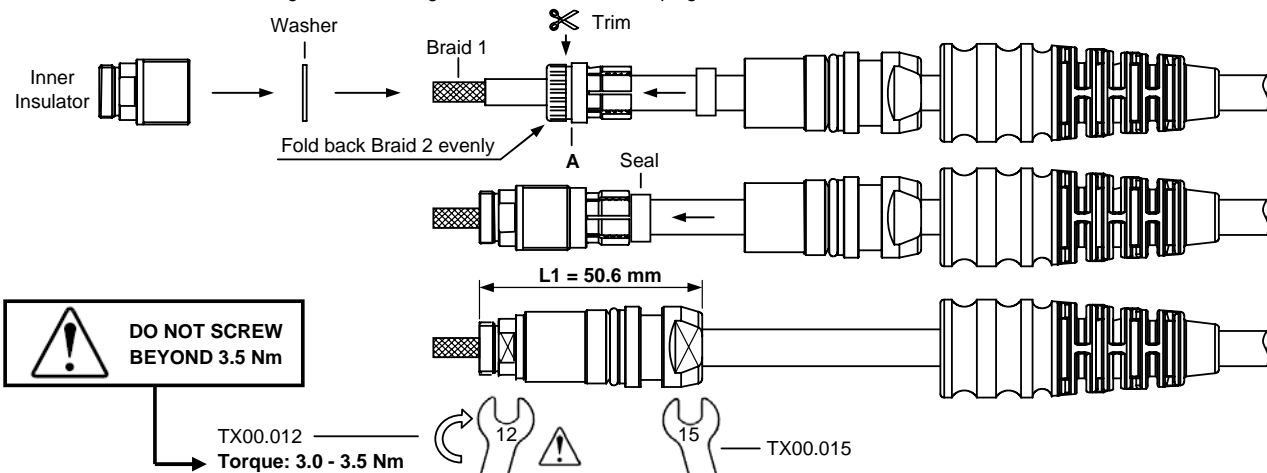
STEP 2 - Slide Back Parts and Strip Cable

- 2.1 Slide the Strain Relief, the Clamp Nut, the Seal and the Cable Clamp onto the cable.
- 2.2 Cut back the Cable Jacket and Braid 2 at the length specified on the figure.
 - ☞ Remove completely the swarf from Braid 2.
 - ☞ Be careful not to mark the Cable Insulator 2.
- 2.3 Cut back Cable Insulator 2 at the length specified on the figure.
 - ☞ Be careful not to mark Braid 1 when cutting Insulator 2.



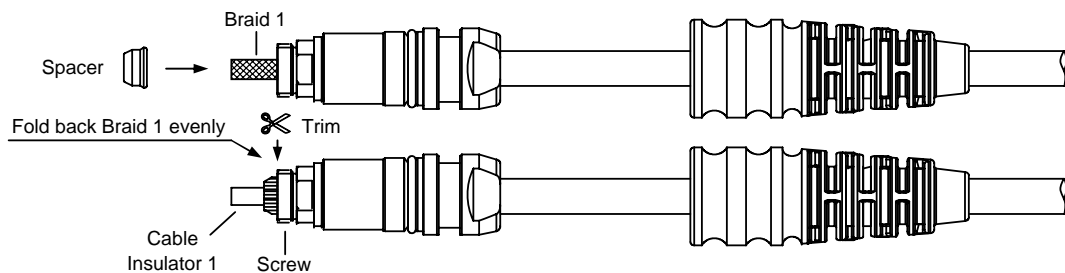
STEP 3 - Tighten Cable Clamp and Braid 2

- 3.1 Slide the Cable Clamp back level to where the Cable Jacket was cut and slide the Seal against the Cable Clamp. Smooth the mesh of Braid 2, and then fold it back over the Cable Clamp to an even width as shown. Trim the folded Braid 2, level with the rim so that it does not reach **A** as shown.
 - ☞ If not folded back evenly, it may cause the screw to become loose.
- 3.2 Slide the Washer against the folded Braid 2.
- 3.3 Thread and tighten the Inner Insulator and the Clamp Nut with 12 mm and 15 mm Flat Spanners.
 - ☞ Be careful not to bend back Braid 1 when sliding the Inner Insulator on the cable.
 - ☞ Be careful not to let the Spanner slip sideways off the flats, because it will damage the Inner Insulator.
 - ☞ Screwing torque: 3.0 - 3.5 Nm. **⚠ Risk of breaking the Insulator. Do not screw beyond the max value!**
 - ☞ Make sure the screw is tight. Check if length **L1** is correct after clamping.



STEP 4 - Fold back Braid 1 over Spacer

- 4.1 Slide the Spacer over Braid 1 and locate it in position in the Inner Insulator.
 - ☞ Be careful not to bend back Braid 1.
- 4.2 Smooth the mesh of Braid 1, and fold it back on the Spacer evenly.
- 4.3 Trim the folded Braid 1, level with the rim so that it does not reach the screw.
 - ☞ If not folded back evenly, it may cause the screw to become loose.

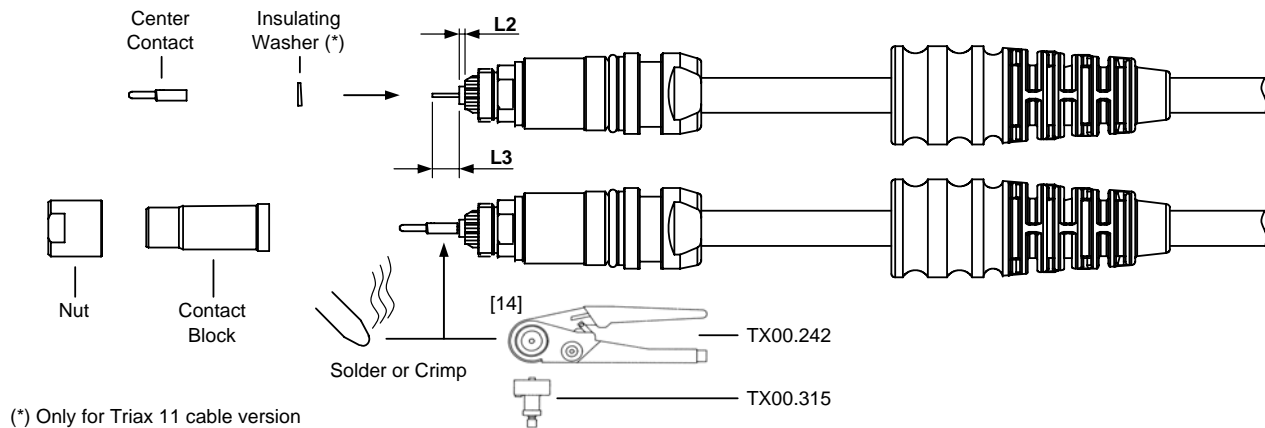


STEP 5 - Mount Center Contact

- 5.1 Cut back the Cable Insulator 1 at distance **L2** from the Spacer as shown.
- ☞ Be careful not to mark the Center Conductor when cutting Insulator 1.
 - ☞ Conductor should be **L3** mm long after the cutback.
- 5.2 Only for Triax 11 cable: slide Insulating Washer on Center conductor of cable.
- 5.3 Solder or crimp Center Contact on Center Conductor of cable.

L2	L3	
0.0 - 1.0	5.0 - 6.0	mm

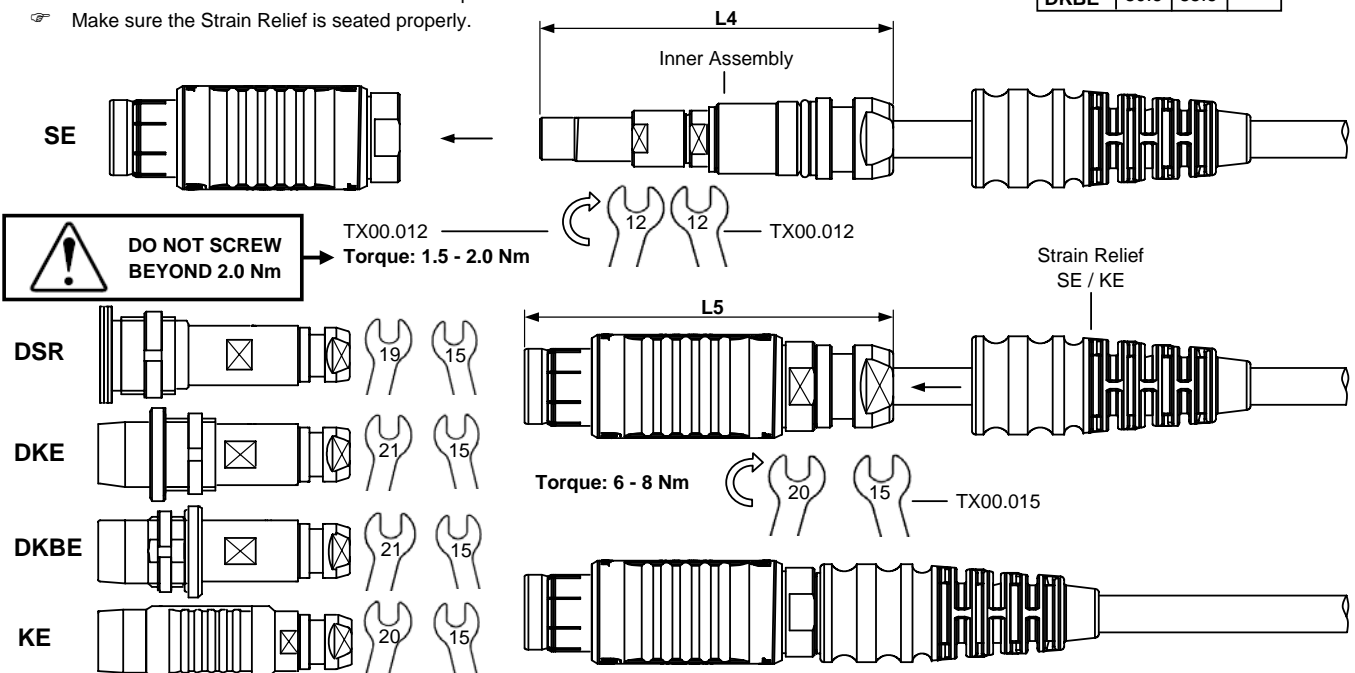
- ☞ For crimping, use Crimping Tool TX00.242 set at position [14] and Positioner TX00.315.



STEP 6 - Mount Contact Block and close Connector

- 6.1 Slide Contact Block and tighten Nut with two 12mm Flat Spanners. Turn only the Spanner that is on the Nut.
- ☞ Screwing torque: 1.5 - 2.0 Nm. ⚠ **Risk of breaking the Insulator. Do not screw beyond the max value!**
 - ☞ Make sure the screw is tight. Check if length **L4** is correct after clamping.
- 6.2 Insert the Inner Assembly into the Body and screw the Clamp Nut with 15mm and 20mm Flat Spanners.
- ☞ Screwing torque: 6 - 8 Nm.
 - ☞ Make sure the screw is not loose. The O-ring should be placed fully inside the body.
 - ☞ Check the length of the connector **L5**.
- 6.3 Slide the Strain Relief over the back of the Clamp Nut.
- ☞ Make sure the Strain Relief is seated properly.

	L4	L5	
SE	80.1	83.5	mm
DSR	80.1	85.4	
KE	80.6	85.6	
DKE	80.6	85.6	
DKBE	80.6	85.6	



NOTE

- Ensure that no swarf from Braid 1 & 2 enters the connector, as it may cause a short circuit.
- In tightening the screws, use only designated spanners and apply the specified torque so that it will not loosen easily or damage the Inner Insulator.